

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-014095**Date Inspected:** 10-May-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** An Qing Xiang, Yu Qi Guo**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance (QA) Inspector Umesh Gaikwad was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

Bay 11, East Tower lift 4, AE Corner Backfill Plate

This QA inspector performed Ultrasonic Testing (UT) of approximately 10% and random Visual Testing (VT) of the area previously tested and accepted by ZPMC Quality Control personnel. This QA inspector generated UT report for this date. The members are identified as Tower Components. The weld designations reviewed are as follows.

ESTL4-2C/L-47, 115

ESTL4-2F/L-109, 44

ESTL4-2G/L-44, 116

ESTL4-2H/L-105, 68

ESTL4-2I/L-109, 70

ESTL4-2J/L-108, 70

ESTL4-2K/L-105, 45

Bay 10, A28 Shear Plate

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This QA inspector performed Magnetic Particle Testing (MT) of approximately 15% and random Visual Testing (VT) of the area previously tested and accepted by ZPMC Quality Control personnel. This QA inspector generated MT report for this date. The members are identified as Tower Components. The weld designations reviewed are as follows.

WD1-A28A/B-45, 52, 76

Bay 10, Bearing Stiffener with A26 Shear plate

This QA inspector performed Magnetic Particle Testing (MT) of approximately 15% and random Visual Testing (VT) of the area previously tested and accepted by ZPMC Quality Control personnel. This QA inspector generated MT report for this date. The members are identified as Tower Components. The weld designations reviewed are as follows.

ND1-A26B/B-51, 47

Bay 10, North Tower Lift 4, BC Corner Triangular Diaphragm & Diagonal Stiffener (GREEN TAG NO. 11667)

This QA Inspector performed green tagging for the BC corner triangular diaphragm and diagonal stiffener of North tower lift 4. The components are identified as Tower components.

This Quality Assurance (QA) Inspector observed the following work in progress:

BAY11

LIFT 4 STRUT PLATE

SMAW welding of weld joint 29 located on ND1-STSA4-6-123M-1.

Welder is identified as 054460. ZPMC QC is identified as Mr. Liu Dao Feng.

The welding variables recorded by QC appeared to comply with WPS-B-T-2113.

SMAW welding of weld joint 55 located on ND1-STSA4-6-135M-2.

Welders are identified as 206189. ZPMC QC is identified as Mr. Liu Dao Feng.

The welding variables recorded by QC appeared to comply with WPS-B-T-2112.

West Tower lift 4, Fitlug at AE Corner

FCAW welding of weld joint 43 located on WSTL4-2K/L.

Welder is identified as 040704. ZPMC QC is identified as Mr. Zhao Mao Mao.

The welding variables recorded by QC appeared to comply with WPS-B-T-4333-Tc-P4-F.

BAY 10

TOWER GRILLAGE PLATE

SMAW welding of weld joint 35B located on SSD1-TL5-1B-F.

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Welder is identified as 500363. ZPMC QC is identified as Mr. Deng Zhi Bing.

The welding variables recorded by QC appeared to comply with WPS-B-T-3213-B-U3b.

SMAW welding of weld joint 2B located on SSD1-TL5-1B-F.

Welder is identified as 500373. ZPMC QC is identified as Mr. Deng Zhi Bing.

The welding variables recorded by QC appeared to comply with WPS-B-T-3213-B-U3b.

PADEYE ON SKIRT PLATE

SMAW welding of weld joint 18 located on SSD1-A434A/D.

Welder is identified as 044511. ZPMC QC is identified as Mr. Jiang Xiao Bo.

The welding variables recorded by QC appeared to comply with WPS-B-P-2111/2114-PADEYE.

BEARING STIFFENER ON A27 SHEAR PLATE

FCAW welding of weld joint 21 located on ED1-A27B/E.

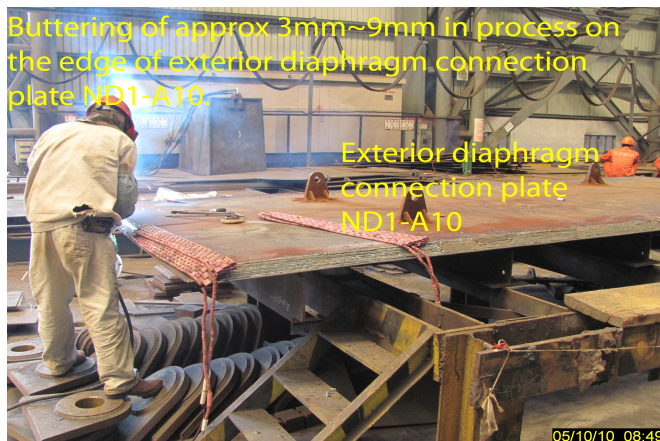
Welder is identified as 204868. ZPMC CWI is identified as Mr. You Qi Guo.

The welding variables recorded by QC appeared to comply with WPS-B-T-2331-Tc-P4-F.

EXTERIOR DIAPHRAGM CONNECTION PLATE (ND1-A10)

During random in process inspection, this QA inspector observed that ZPMC personnel was performing buttering of about 3mm~9mm on the edge of exterior diaphragm connection plate of ND1-A10. Welder is identified as 053869. ZPMC QC is identified as Mr. Yu Zhi Lai. The welding variables recorded by QC appeared to comply with WPS-345-FCAW-2G(2F)-REPAIR.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Skyler Guest : 15000422360, who represents the Office of Structural Materials for

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your project.

Inspected By: Gaikwad,Umesh

Quality Assurance Inspector

Reviewed By: Clifford,William

QA Reviewer